

Date: Friday, 06/07/2007 9:16:09 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WINDOW	
Job Number	: 33064		Part Number	: D2958	
Estimate Number	: 10063		Drawing Number	: D2958 REV. E & Pecah 607.07.09	
P.O. Number	:		Project Number	: N/A	
This Issue	: 06/07/2007	S.O. No. :	Drawing Revision	: D2 & Pecah	
Prsh Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 13/07/2007 Qty: 20 Um: Each	
Previous Run	: 33064				
Written By	:				
Checked & Approved By	:				
Comment	: E 04.09.25 Done by outside contract SM Est 07.06.26 Thermoform in house DL				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	MACRLICS125	1/8" Polycast II Sheet		
		Comment: Qty: 2.5800 sf(s)/Unit Total: 51.6000 sf(s) 1/8" Polycast II Sheet		HB 07-07-10 → FOR ENG. PURPOSES ONLY
2.0	WATER JET	FLOW WATER JET		Make 1 only - for engineers approval OK TO MAKE 20
		Comment: FLOW WATER JET		RELEASED INSPECT PARTS AS THEY COME OFF MACHINE HB 07-07-10
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		24
4.0	QC8	SECOND CHECK		En 07/07/10 X24
5.0	THERMOFORMING	THERMOFORMING MACHINE		
		Comment: THERMOFORMING MACHINE Thermoform as per Dwg D2958 and Folio FTA005		
		Dwg. Rev. <u>E</u> Folio Rev. <u>A.</u>		07.07.09 JH

Date: Friday, 06/07/2007 9:16:09 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 33064

Part Number: D2958

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
7.0	QC5	INSPECT WORK TO CURRENT STEP
8.0	PACKAGING 1	PACKAGING RESOURCE #1
9.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE *07.07.10 WL*

Comment: INSPECT WORK TO CURRENT STEP *07.07.10*

Comment: PACKAGING RESOURCE #1 *-12 S40*

Comment: FINAL INSPECTION/W/O RELEASE *07.08.10 12*

Job Completion



07.08.15

Date: Thursday, 6/21/2007 2:29:28 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WINDOW
Job Number	33064		
Estimate Number	10063		
P.O. Number	:	Part Number	D2958
This Issue	6/21/2007	Drawing Number	D2958 REV. D
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	D
Previous Run	30698	Material	:
Written By	:	Due Date	7/6/2007
Checked & Approved By	<i>PD OF 06 22</i>	Qty:	20
Comment	E 01.09.25 Done by outside contract SM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING <i>forwards for you</i>
		Comment: PURCHASING Issue P/O: _____ Order per Dwg D2958 Supplier: -Canus Material: 1/8" thick clear Polycast sheet Supplier should protect window with protective film Material release note required
2.0	D2958P	Window
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Window
3.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>M-ACRYLIC S(25) B</i>
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Trim as per Template DT8568. 2-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 33064

Part Number: D2958

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.07.09	2	MAKE 1 PART FOR Verification of new drawing Positive Recall 07.07.09. Verify machined part to drawing. TRIAL FIT NEW PART TO D2958 FRAME	Dh.	07.07.09	1	✓ 02.08.10	✓ 07.07.10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

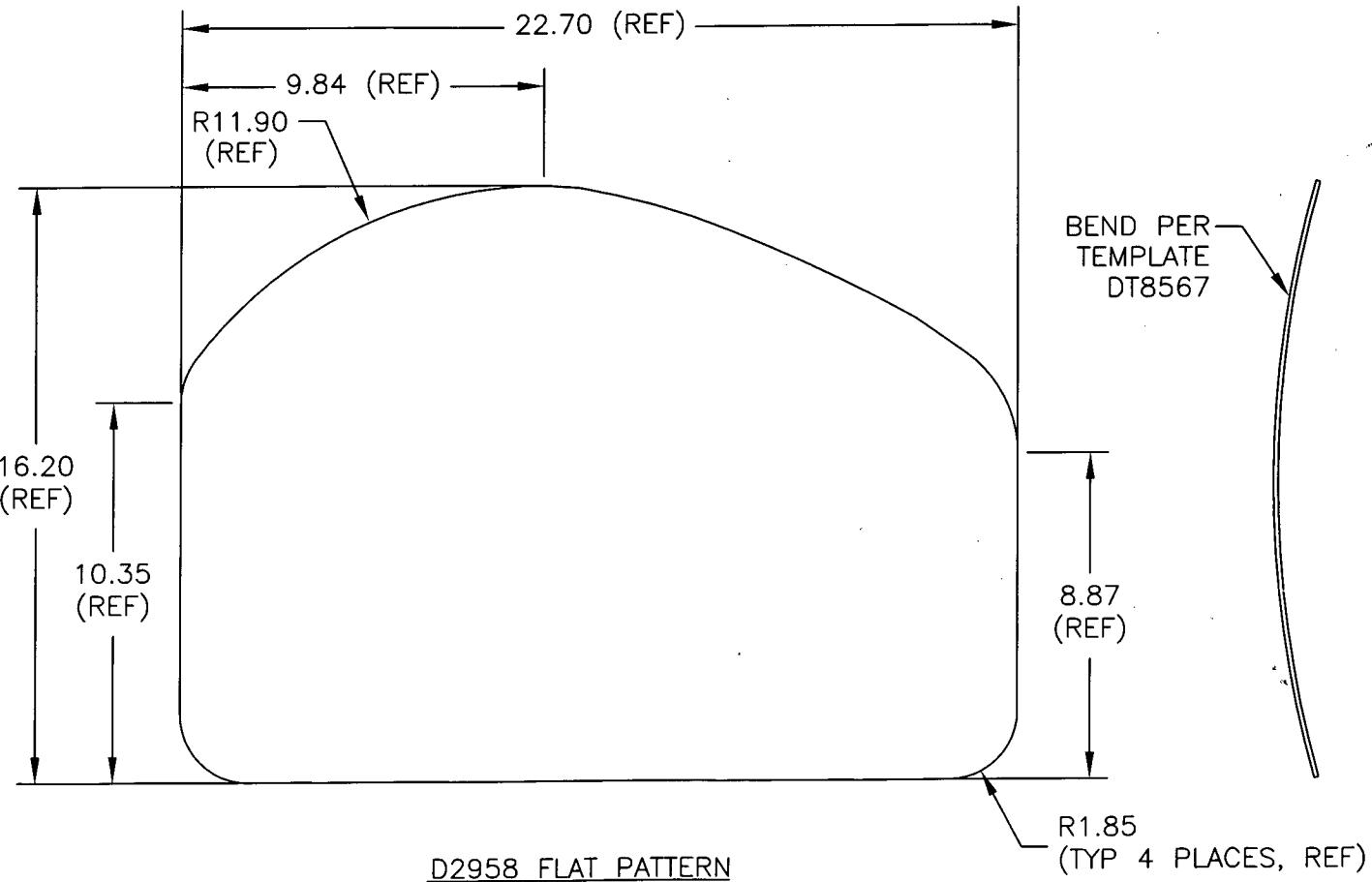
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

07.07.09

DESIGN <i>QP</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2958	REV. E SHEET 1 OF 1
DATE 07.07.06		TITLE WINDOW	SCALE 1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	
C	01.05.30	REMOVE HOLES, UNIFORMLY SMALLER	
D	06.04.13	UPDATE MATERIAL PER NCR 029	
E	07.07.06	REDESIGN PER PAR 188	



D2958 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ROUTER PER TEMPLATE DT8568
- 3) BEND PER TEMPLATE DT8567
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	133664
Description: WINDOW	Part Number:	D2958 E
Inspection Dwg:	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

See Work Order Changes.

FAI for 1 Item positive recall
for fit verification prior to
producing batch

Measured by:	HB	Audited by:	EN	Prototype Approval:	D.H.
Date:	07-07-10	Date:	07/07/10	Date:	07.08.15-
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	